

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, July 29, 2011 11:48:59 AM



Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 7/29/2011 **Start Qty:** 20.00

**Cust Item ID:**

Required Date: 8/9/2011 **Req'd Qty:** 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:




Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				20	0		
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr <input type="checkbox"/> 2- C'sink as per Dwg D2873								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				count			

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NOTE: Date & initial all entries

Work Order ID 72562

Friday, July 29, 2011 11:48:59 AM



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Item ID: D2873-045

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 7/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

20 4 11/08/11

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

20x 11/08/11

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 02-Identify as D2873-045

11/08/11 20

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Work Order ID 72562

Friday, July 29, 2011 11:48:59 AM



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Item ID: D2873-045

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 7/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 W/O 1/17		accepts (720)			
200 Packaging Packaging	Identify as per dwg & Stock Location: <u>mat</u> Memo	0.00 0.00					11/8/17	(20)	
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/8/18	(20)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 29, 2011 11:49:05 AM

Page 1

Work Order ID: 72562

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 7/29/2011

Required Date: 8/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

2

40



Nut Plate

Location

Loc Qty

Loc Code

ST302

25

118267

25

ST303

1

116914

1

M6061T6B0.375X01.00
0

Purchased

No

180

f

4.9366

0.225

4.736842



6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT002

4.9366

116963

2.6766

• 117653

2.26

MS20426AD4-6

Purchased

No

180

Each

849.0000

4

80



Rivet

please
take out
of stock.

* M110162
used it because other
is out of stock.

Location

Loc Qty

Loc Code

ST317

849

110139 -

355

117505

494

→ 1.2

2.6766
2.26

8/11/08/17

34

M118510 (46x)

8/11/08/17
M118542 (40x)

FK. 11/08/08

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DART AEROSPACE LTD		Work Order: 72562
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓		Vern	6A-01
1.000	+/-0.010	1.000	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.131	✓		"	"
0.359	+/-0.010	0.358	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.318	✓		"	"
1.000	+/-0.010	1.006	✓		"	"
0.250	+/-0.010	0.249	✓		"	"
0.061	+/-0.010	0.059	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.230 x 0.125	✓		"	"

Measured by: B.A	Audited by: amr	Prototype Approval: N/A
Date: 11/08/11	Date: 11/08/12	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	[Signature]

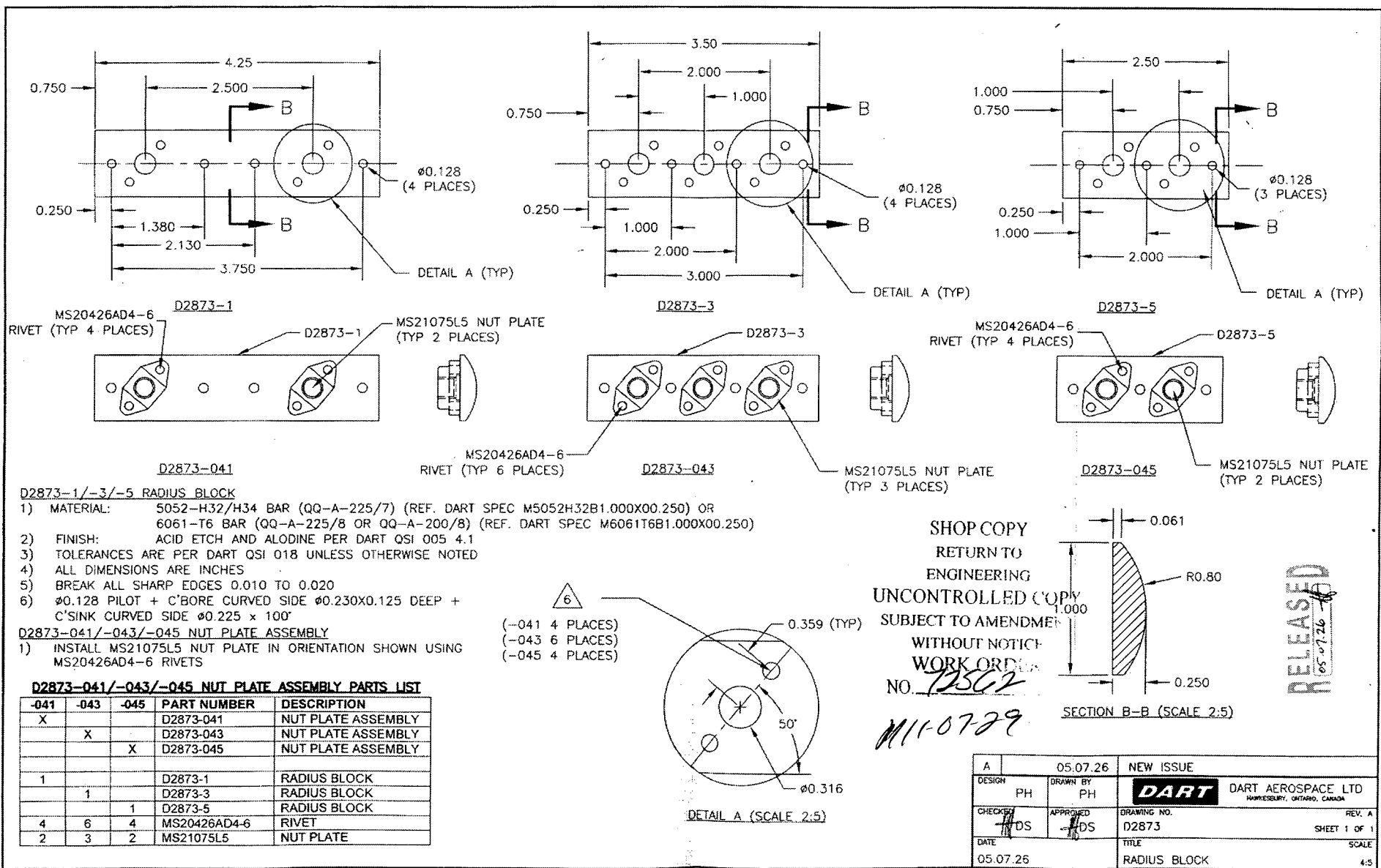
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D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

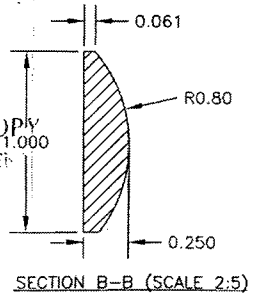
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *7562*



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED <i>IDS</i>	APPROVED <i>IDS</i>	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5

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